

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023311**Date Inspected:** 07-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Mr. Geng Wei		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No
Rod Oven in Use:	Yes	No N/A
Weld Procedures Followed:	Yes	No N/A
Verified Joint Fit-up:	Yes	No N/A
Approved WPS:	Yes	No N/A
Delayed / Cancelled:	Yes	No N/A

Bridge No: 34-0006**Component:** OBG Segment Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Ramesh Gade, was present during the times noted above for observations relative to the work being performed.

OBG Segment 13BE / Bay 14

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 3G position of weld # SEG3009G-120. The welder is identified as 068920. Quality Control (QC) is identified as Wang Xu. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

OBG Segment 13CE / Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 3G position of weld # SEG3011H-067. The welder is identified as 051359. Quality Control (QC) is identified as Wang Xu. The welding variables recorded by QC appeared to comply with WPS-B-P-2213-TC-U4b-FCM-1.

OBG Segment 14E / Bay 14

WELDING INSPECTION REPORT

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This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 3G position of repair weld # SEG3019BB-111, as per B-WR # 20589. The welder is identified as 067864. Quality Control (QC) is identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G(3F)-FCM-repair.

OBG Segment 14E / Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 2G position of weld # SEG3019AA-003. The welder is identified as 054013. Quality Control (QC) is identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with WPS-B-P-2212-B-U3b-FCM-1. See attached photograph Pic_001.

OBG Segment 14E / Bay 14

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 2G position of weld # SEG3019S-266. The welder is identified as 067079. Quality Control (QC) is identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with WPS- B-T-2232-ESAB.

OBG Segment 14E / Bay 14

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 2G position of weld # SEG3019T-053. The welder is identified as 067079. Quality Control (QC) is identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with WPS- B-T-2232-ESAB.

OBG Segment 14E / Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4G position of weld # SEG3019U-006. The welder is identified as 044772. Quality Control (QC) is identified as Lv Li Qing. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1. See attached photograph Pic_002.

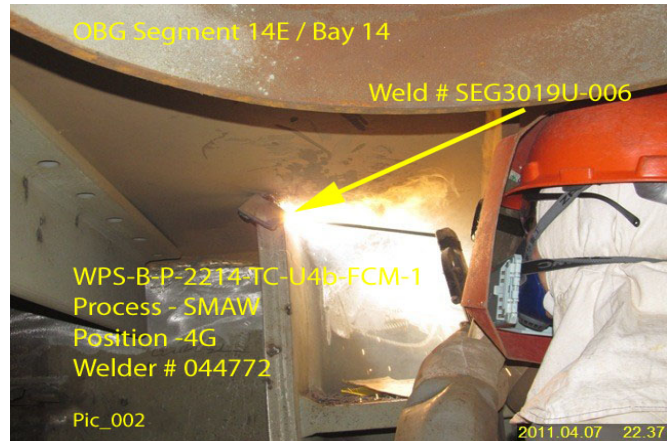
OBG Segment 14E / Bay 14

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 2G position of weld # SEG3019F-015. The welder is identified as 067079. Quality Control (QC) is identified as Lv Li Qing. The welding variables recorded by QC appeared to comply with WPS- B-T-2232-ESAB.

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Summary of Conversations:

No relevant conversations reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (+86)15000 42 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Gade,Ramesh	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
